

# Work Order ID 68077

Wednesday, April 06, 2011 10:05:10 AM



Page 1

Item ID: D3874-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3874

Rev A

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

x2

*Dh*  
11/04/12

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

x2

*Dh*  
11/04/12

Temp: 340°F

Time IN: 4:00 pm 11/04/12

Time OUT: 7:00 am 11/04/12

**Work Order ID 68077**

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Page 2

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Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA038 using tool DT9474  
Dwg Rev: A  
Folio Rev: B

x2

Dh  
11/04/12

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x2

Dh  
11/04/12

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml

11

04

12

(2)

# Work Order ID 68077

Wednesday, April 06, 2011 10:05:10 AM



Page 3

Item ID: D3874-1

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Item Name: Floor Protector

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

(x1)

x1

Wh

4/04/19

PTO →

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

x1

Wh

4/04/20

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control


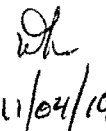
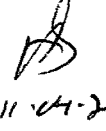
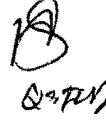
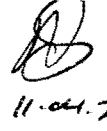
8/10/28

(x1)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3874-1 PAR #: N/A Fault Category: Thermalforming NCR: (Yes) No DQA: 11 Date: 11.05.05  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/05/06 Date: 11/05/06

NCR: 68077		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/04/19	11/0	Wrong TRIM. Cut too far on Router TABLE. P.C. Lack of Attention: Darryl Setup		OPERATOR ERROR. SCRAP 1 part.	 11/04/19	 11.04.27	 11.04.27	 11.04.27

NOTE: Date & initial all entries

**Work Order ID 68077**

Wednesday, April 06, 2011 10:05:10 AM



Page 4

Item ID: D3874-1

Accept



Setup Start



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Stop



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Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Memo

0.00

Packaging

11/4/28 5/10

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/4/29 8

11-09-28



# Picklist Print

Wednesday, April 06, 2011 10:05:07 AM

Page 1

Work Order ID: 68077



Parent Item: D3874-1



Parent Item Name: Floor Protector

Start Date: 4/5/2011

Required Date: 4/6/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev A 09.02.06 New Issue DL  
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.118-90318-08

Purchased

No

100

sf

2,333.910

4.38

8.76



Lexan Sheet

Location

Loc Qty

Loc Code

therm

2333.91

2333.91

113127

8.76 sg DL

11/04/20

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 68077
<b>Description:</b> Floor Protector		<b>Part Number:</b> D3874-1
<b>Inspection Dwg:</b> D3874	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

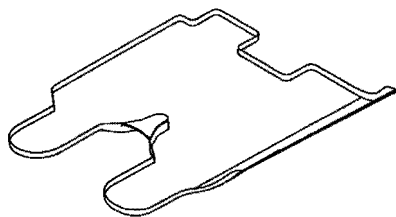
Measured by: Wh Date: 11/04/20

#### TRIMMING SECTION

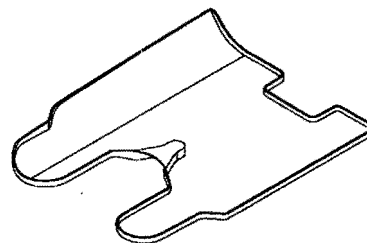
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.053"	✓		Visual	
0.065	Min	0.080"	✓		CAL TH-01	
0.5	Min	0.57"	✓		Visual	

Measured by: Wh Date: 11/04/20  
 Audited by: BB Date: 11/04/27  
 Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>Wh</u>



**D3874-1 FLOOR PROTECTOR**



**D3874-2 FLOOR PROTECTOR**

*w/068077*

**RELEASED**  
*29/10/05/11*

A	NEW ISSUE	PH	09.01.29
REV	DESCRIPTION	BY	DATE
DESIGN		PH	
DRAWN		PH	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.29		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3874</b>	REV. A
TITLE <b>FLOOR PROTECTOR</b>	SHEET 1 OF 3
SCALE NTS	

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8 7 6 5 4 3 2 1

D

C

B

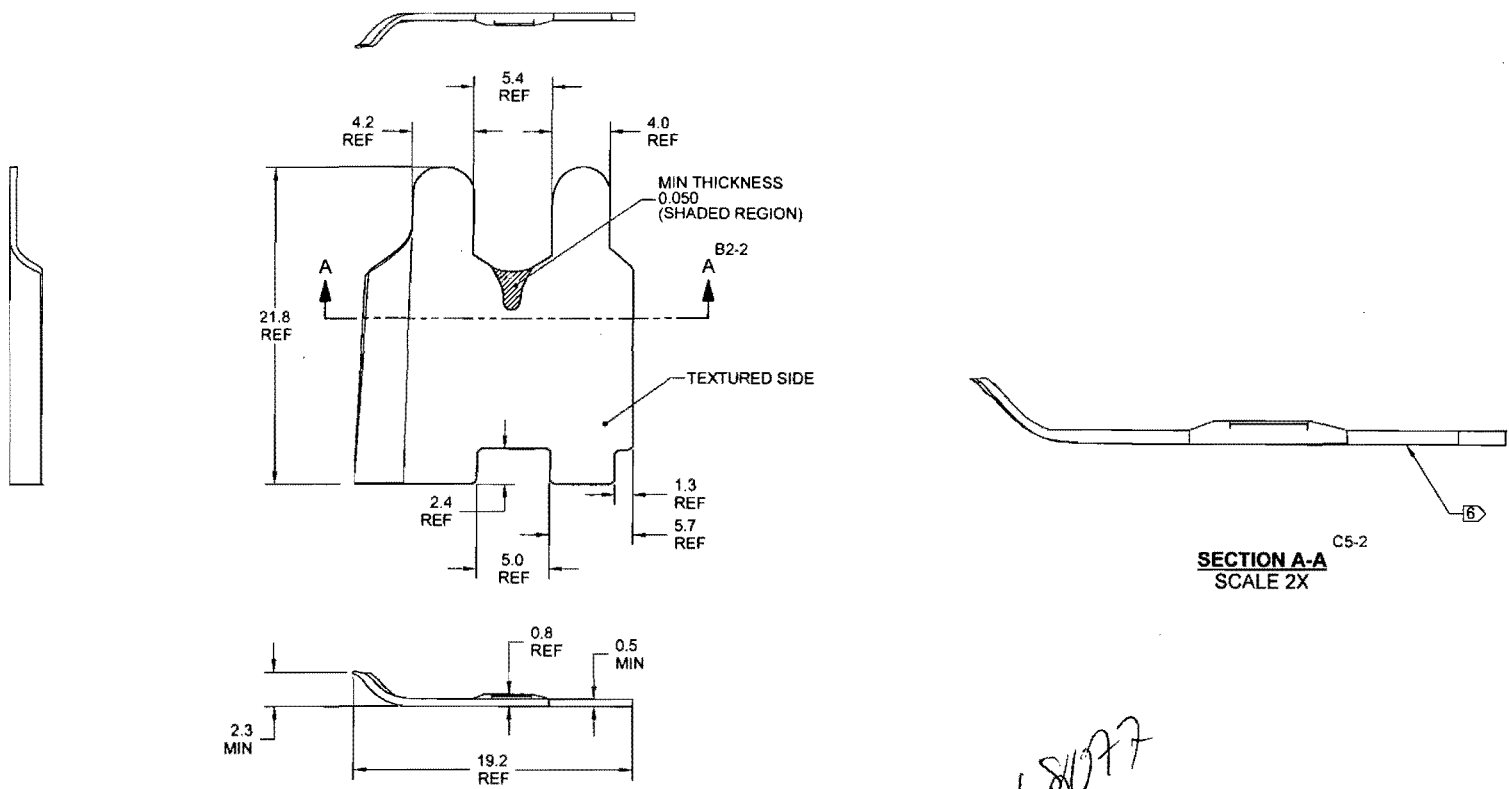
A

D

C

B

A



SECTION A-A  
SCALE 2X

**D3874-1 FLOOR PROTECTOR**

**NOTES:**

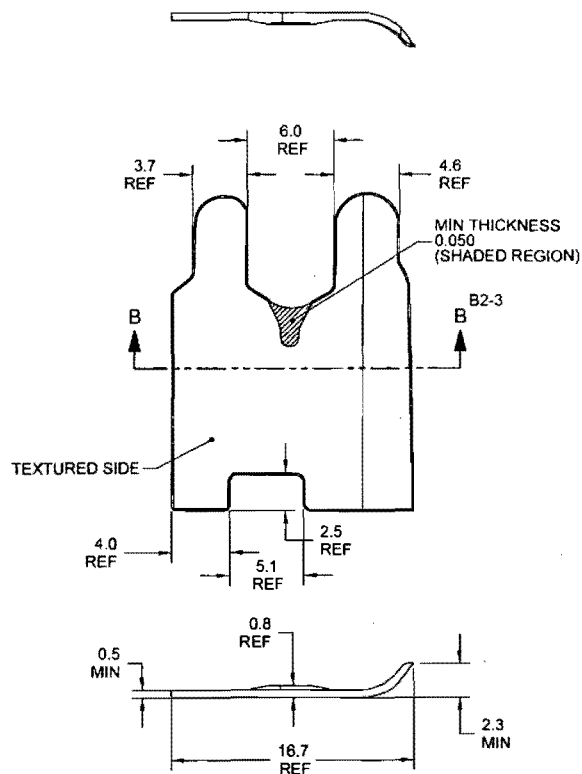
- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

68077

**RELEASED**  
09/25/05

DESIGN	PAH	<b>DART AEROSPACE LTD</b>	
DRAWN	PAH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PAH	DRAWING NO.	REV. A
MFG. APPR.	PAH	D3874	SHEET 2 OF 3
APPROVED	PAH	TITLE	SCALE
DE APPR.	PAH	FLOOR PROTECTOR	NTS
DATE	09.01.29	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



SECTION B-B  
SCALE 2X

# **D3874-2 FLOOR PROTECTOR**

## **NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

DESIGN	REV. A	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	REV. A			
CHECKED	REV. A		DRAWING NO.	REV. A
MFG. APPR.	REV. A		D3874	SHEET 3 OF 3
APPROVED	REV. A		TITLE	SCALE
DE APPR.	REV. A		FLOOR PROTECTOR	NTS
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0.065"  
DL 11/04/20.

**RELEASED**  
11/05/08